

Date: Thursday, 1/17/2008 3:24:01 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HORIZONTAL TUBE
Job Number : 36815	
Estimate Number : 12313	
P.O. Number :	Part Number : D34737
This Issue : 1/17/2008 S.O. No. :	Drawing Number : D3473 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : / /	Drawing Revision : B
Previous Run : 34421	Material :
Written By :	Due Date : 2/10/2008 Qty: 10 Um: Each
Checked & Approved By : <u>08 01 18</u>	
Comment : Est Rev:A New Issue 06-03-02 JLM	
Est Rev:B As per Rev B 06-05-24 JLM	

OK per Rev. B
 with Markups
 08.01.18
 12

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S26GA 304/316 0.018 SHEET



8



Comment: Qty.: 0.6305 sf(s)/Unit Total : 6.3053 sf(s)

304/316 0.018 SHEET

Batch: 105591 B 8-1-23

2.0 WATER JET 105591 FLOW WATER JET



Comment: FLOW WATER JET

Cut as per Dwg D3473

Dwg Rev: B

Prog Rev: B

HB 8-1-23



3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



HB 8-1-23



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

05/06/05 (12)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.

HB 8-1-23

2-Roll & Bead as per Dwg D3473

ME

08.02.04

3-Spot weld as per Dwg D3473

ME

08-02-04

(12)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/02/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/17/2008 3:24:01 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HORIZONTAL TUBE

Job Number: 36815

Part Number: D34737

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC11

VISUAL INSPECTION OF SPOT WELDING



Comment: VISUAL INSPECTION OF SPOT WELDING

SB 08/02/04

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 08/02/04 (12)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

MF 08-02-04

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SB 08/02/04

Job Completion



run 2008/2/04 (12)

W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			


NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order:	36815
Description: Horizontal Tube		Part Number:	D3473-7
Inspection Dwg: D3473 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
8.810	+/-0.010	8.810	X			
3.11	+/-0.030	3.111	X			
2.81	+/-0.030	2.808	X			
0.018	+/-0.010	.018	X			

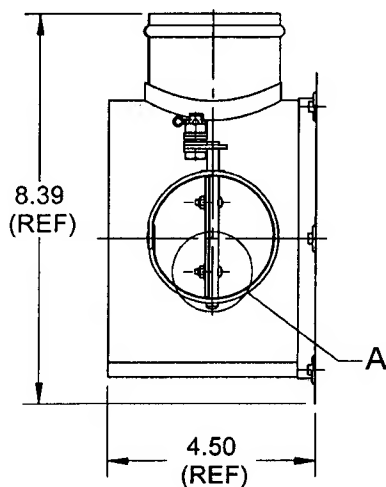
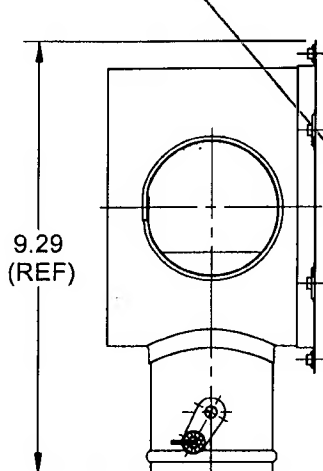
Measured by: IB	Audited by: 	Prototype Approval:	N/A
Date: 8-1-23	Date: 08/01/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.02	New Issue	KJ/JLM	
B	07.10.30	0.018 dimension added	KJ/EC/DD 	



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3473	REV. B SHEET 1 OF 7
DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:4
A	06.02.07	NEW ISSUE	
B	06.05.16	D3473-5F/-7F: 9.750 & 8.810 WERE 9.60 & 8.60	

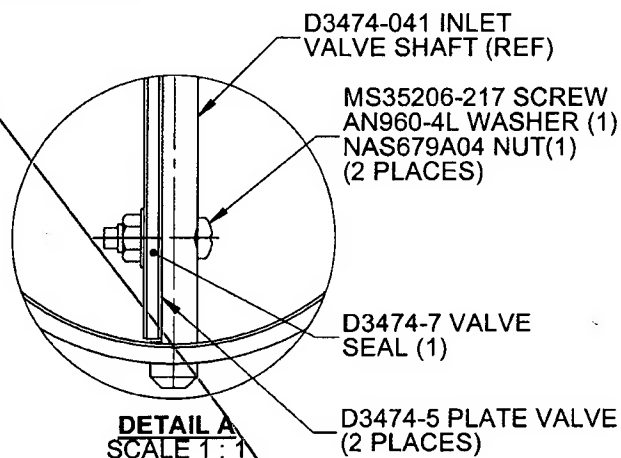
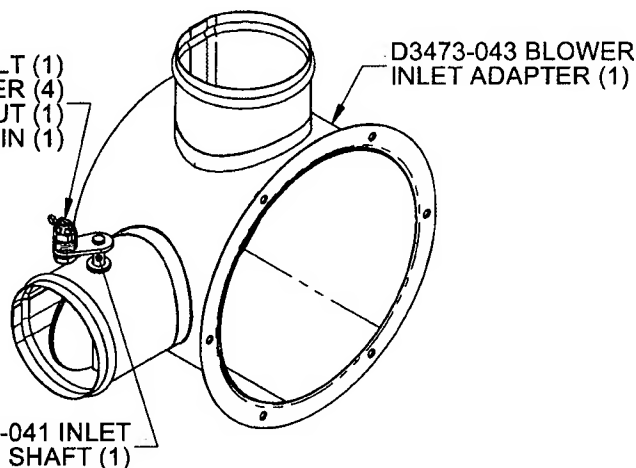
RELEASED
06-05-16 #



D3470-9 BOLT (1)
AN960-416 WASHER (4)
AN310-4 NUT (1)
MS24665-153 COTTER PIN (1)

UNDER REVIEW

Dirt & Manufacturing
Changes



DETAIL A
SCALE 1:1

D3473-041 BLOWER INLET ADAPTER

NOTES:

- 1) IDENTIFY WITH DART P/N D3473-041 USING FINE POINT PERMANENT INK MARKER
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3473-041	BLOWER INLET ADAPTER
1	D3470-9	BOLT
1	D3471-043	BLOWER INLET WELDMENT
1	D3474-041	INLET VALVE SHAFT
2	D3474-5	BUTTERFLY VALVE
1	D3474-7	BUTTERFLY VALVE SEAL
1	AN310-4	NUT
2	AN960-4L	WASHER
4	AN960-416	WASHER
1	MS24665-153	COTTER PIN
2	MS35206-217	SCREW
2	NAS679-A04	NUT

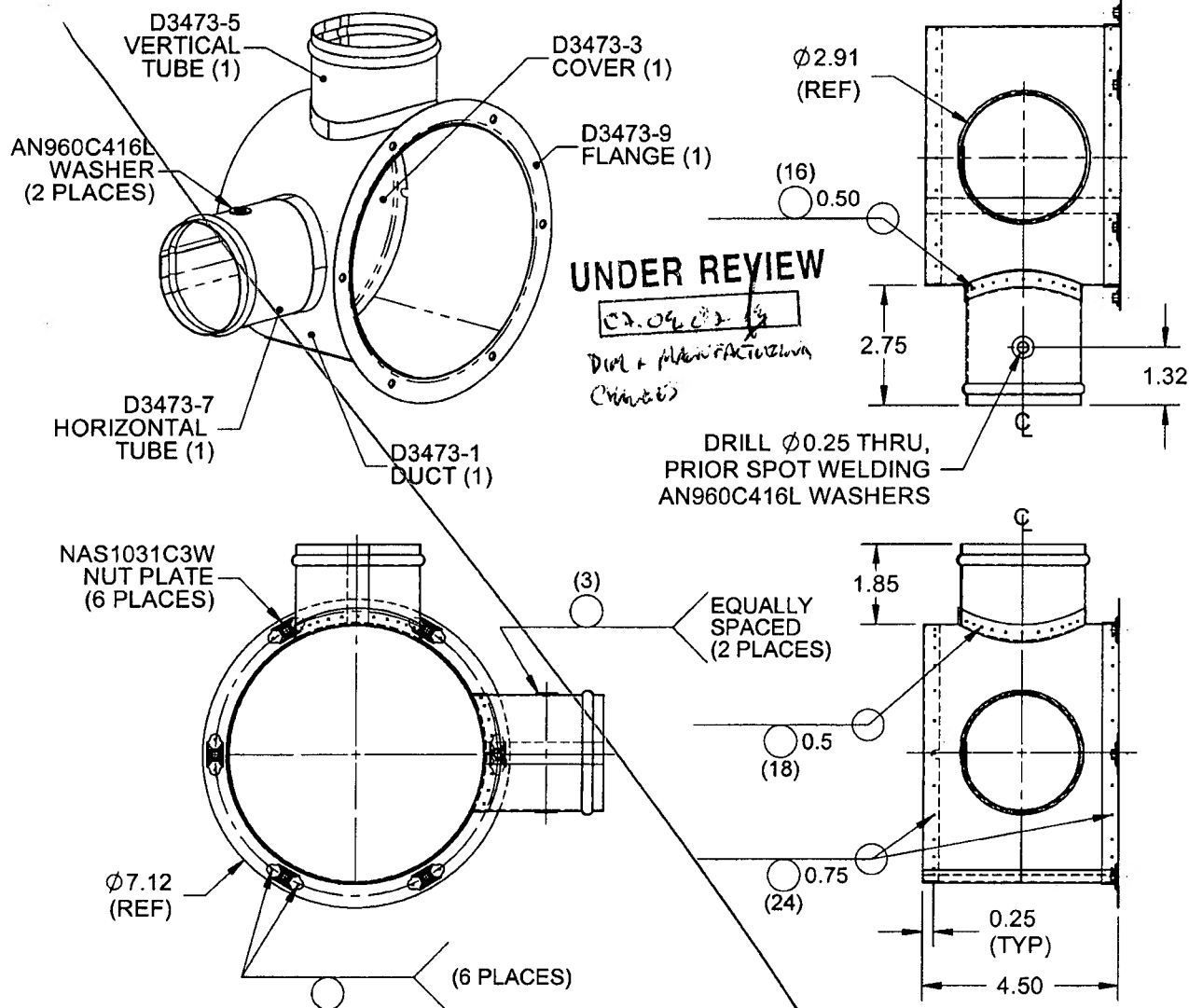
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3473	REV. B SHEET 2 OF 7
DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:4

RELEASED
06.05.16**D3473-043 BLOWER INLET WELDMENT****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3473-043	BLOWER INLET WELDMENT
1	D3473-1	DUCT
1	D3473-3	COVER
1	D3473-5	VERTICAL TUBE
1	D3473-7	HORIZONTAL TUBE
1	D3473-9	FLANGE
2	AN960C416L	WASHER
6	NAS1031C3W	NUT PLATE

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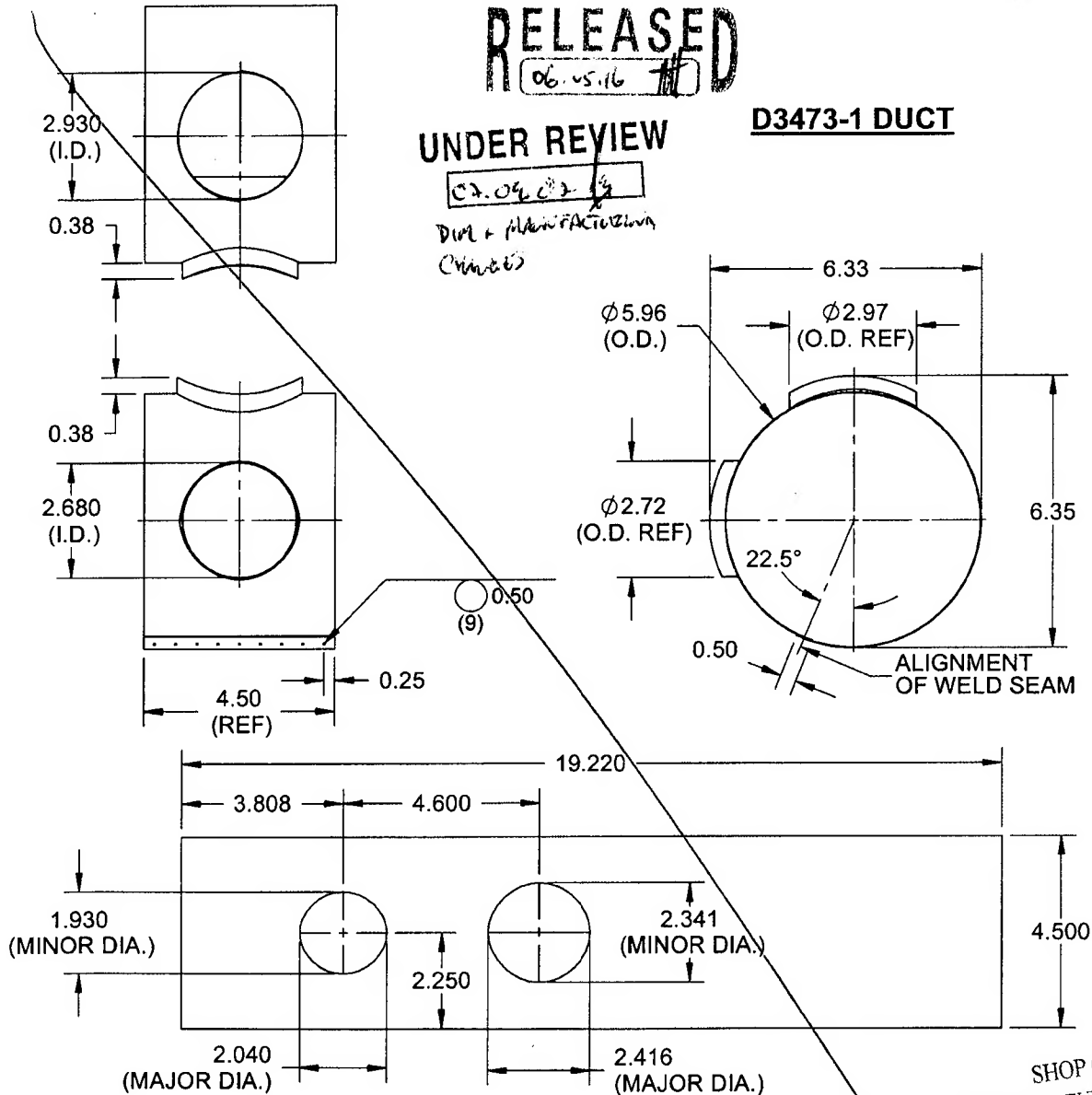
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DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:4

RELEASED
06.05.16**UNDER REVIEW**

02.04.16

Dim + MANUFACTURING
CHECK**D3473-1 DUCT****D3473-1F DUCT FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED)
2B FINISH 26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

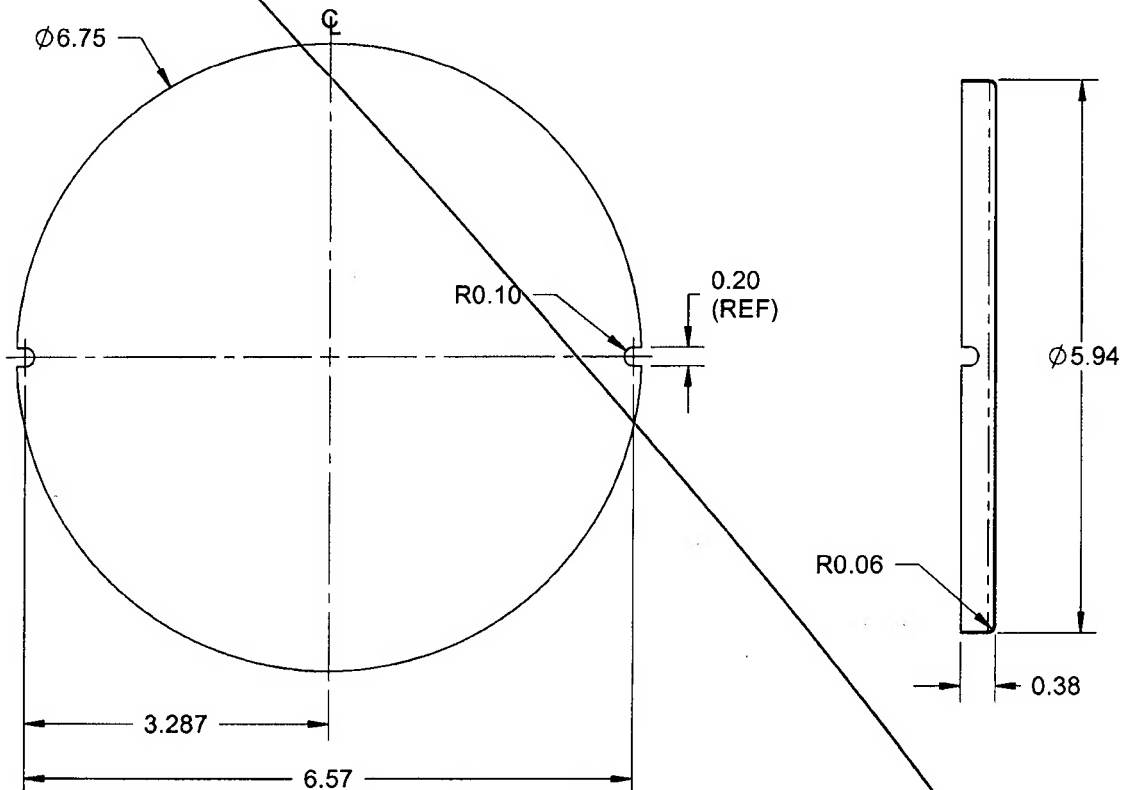
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DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:2

RELEASED
06-05-16 *H***UNDER REVIEW**
02.09.16 *B*
Dir & Manufacturing
Changes**D3473-3F COVER FLAT PATTERN****D3473-3 COVER****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

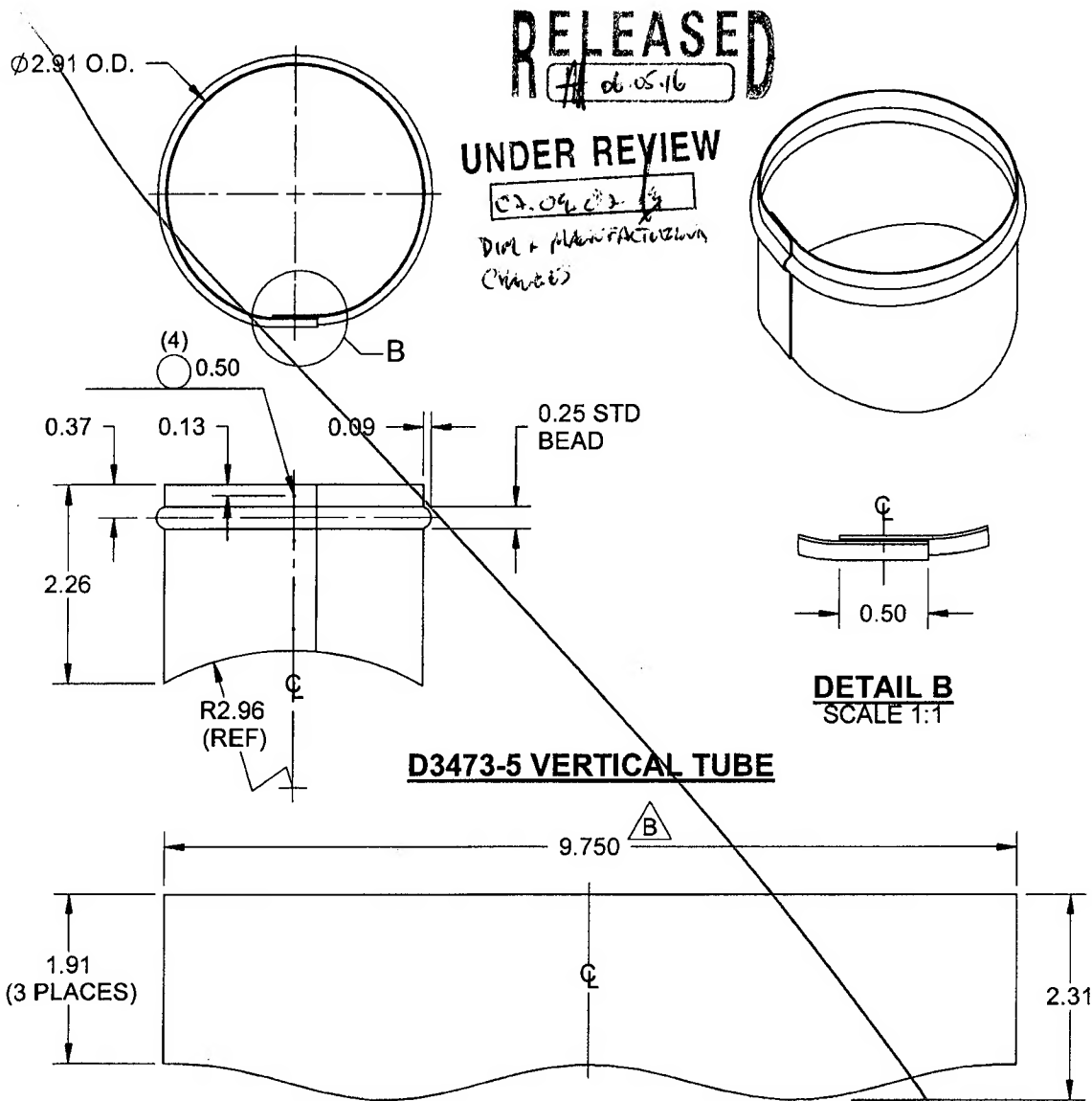
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DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:2

**D3473-5F VERTICAL TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

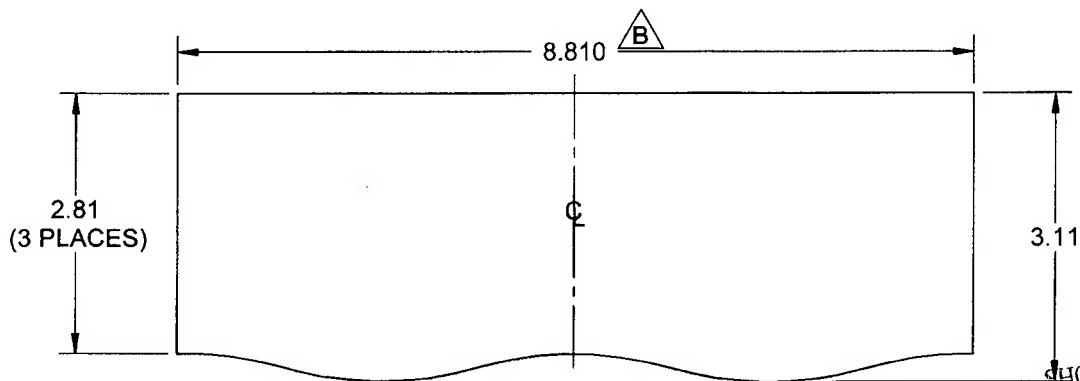
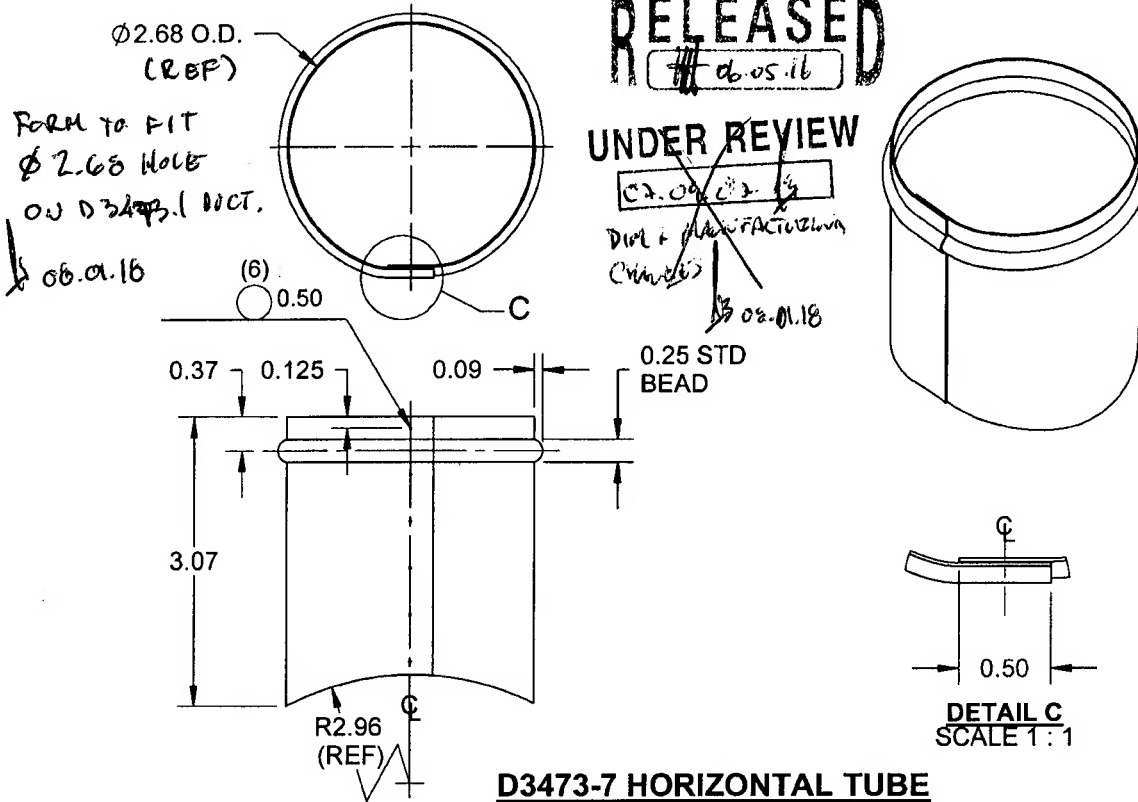
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DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:2

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

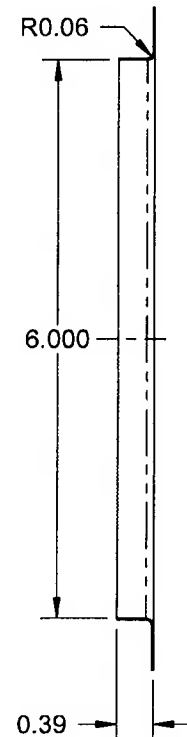
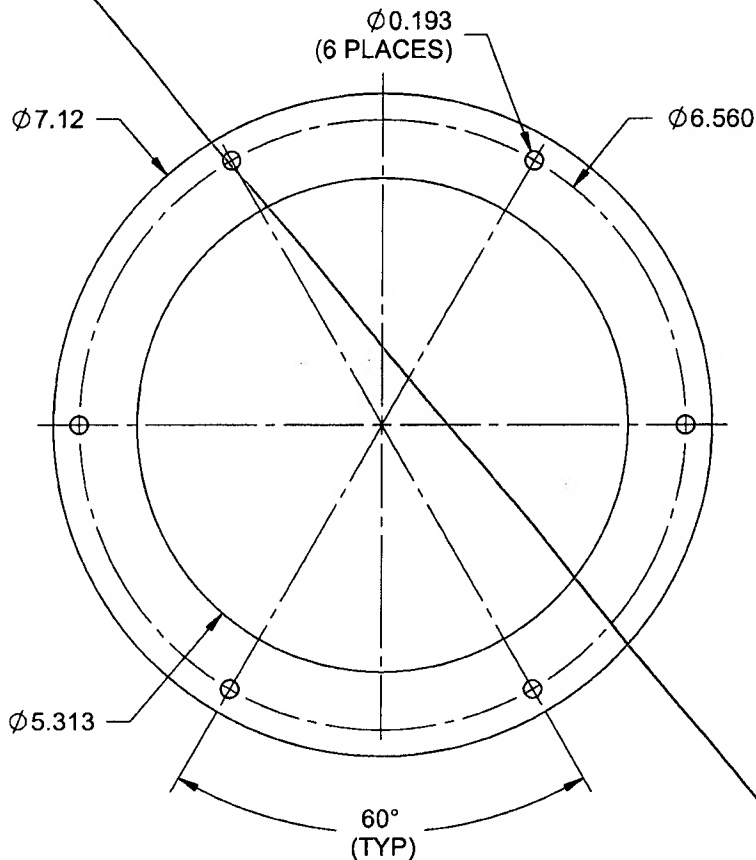
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+ MAKEUPS.
06.01.18

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CHECKED <i>HA</i>	APPROVED <i>HA</i>	DRAWING NO. D3473	REV. B SHEET 7 OF 7
DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:2

UNDER REVIEW*02.04.16**Dim + MANUFACTURING
Changes***RELEASED**
06.05.16**D3473-9F FLANGE FLAT PATTERN****D3473-9 FLANGE
BENDING DETAIL****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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SPOT WELD TEST RECORD
AMS-W-6858A
CLASS 'C'

TEST NO#: 63

EMPLOYEE: Milene Fautery

PART NUMBER: D3473-7

JOB NUMBER: B36815

MATERIAL TYPE: 304L

MATERIAL THICKNESS: 0.078

GROUP SPECIFICATION



Group 1: Aluminum & magnesium



Group 2: Iron; nickel; cobalt



Group 3: Titanium SS

TEST RESULTS

	PASS	FAIL
VISUAL:	[<u>✓</u>]	[]
PENETRATION:	[<u>✓</u>]	[]
PULL STRENGTH:	[<u>✓</u>]	[]

PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 08/02/04
QUALIFIER: SB